

Work Order ID 76807

76807

Page 1

Monday, November 21, 2011 11:25:08 AM

Item ID: D2662-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, RH In 206

Start Date: 11/21/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/16/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date: 11/21/

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2662	Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 & DWG

DWG REV: E

FOLIO REV: AA

Re 11.12.18

10

0

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

Re 11.12.18

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Monday, November 21, 2011 11:25:08 AM

Item ID: D2662-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, RH In 206
 Start Date: 11/21/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>9:30</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>10:00</u>								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>435</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

10X10 M-L 11/12/20

10 p 11/12/20
counted

11/12/20 100

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Work Order ID 76807***76807***

Page 4

Monday, November 21, 2011 11:25:08 AM

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Revision ID: Stop *NS2*
Item Name: Saddle, RH In 206
Start Date: 11/21/2011 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 12/16/2011 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MR
11-12-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

Monday, November 21, 2011 11:25:13 AM

Work Order ID: 76807

76807

Parent Item: D2662-2

D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 11/21/2011

Required Date: 12/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	152.0000	1	10			

D6101-001

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	152	
66965	1	
69677	2	
73774	60	
74648	21	
74679	68	

→ 76836

10.0, B.A 11/21/13

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 76807
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140	.125	.125	.125	.125	.125	.125	.125
B	0.100	0.140	.135	.135	.135	.135	.135	.135	.135
C	1.125	1.145	1.136	1.136	1.136	1.136	1.136	1.136	1.136
D	0.615	0.685	.685	.685	.685	.685	.685	.685	.685
E	0.240	0.260	.248	.248	.248	.248	.248	.248	.248
F	1.313	1.343	1.325	1.325	1.325	1.325	1.325	1.325	1.325
G	0.210	0.230	.218	.218	.218	.218	.218	.217	.217
H	0.100	0.180	.130	.130	.130	.130	.130	.130	.130
I	2.470	2.510	2.491	2.491	2.491	2.491	2.491	2.491	2.491
J	1.565	1.585	1.576	1.576	1.576	1.576	1.576	1.576	1.576
K	0.235	0.240	.237	.237	.237	.237	.237	.237	.237
L	0.100	0.120	.109	.109	.109	.109	.109	.109	.109
M	0.990	1.010	.999	.999	.999	.999	.999	.999	.999
N	0.510	0.515	.512	.512	.512	.512	.512	.512	.512
O	5.990	6.010	6.000	6.000	6.000	6.000	6.000	6.000	6.000
P	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318	.313	.313	.313	.313	.313	.313	.313
S	0.315	0.322	.316	.316	.316	.316	.316	.316	.316
T	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367	1.362	1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807	.797	.797	.797	.797	.797	.797	.797
W	0.540	0.560	.548	.548	.548	.548	.548	.548	.548
X	1.674	1.684	1.679	1.679	1.679	1.679	1.679	1.679	1.679
Y	0.257	0.262	.257	.257	.257	.257	.257	.257	.257
Z	0.912	0.932	.922	.922	.922	.922	.922	.922	.922
AA	0.490	0.510	.50	.50	.50	.50	.50	.50	.50
AB	0.178	0.198	.188	.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: 29	Audited by: B.A
Date: 11.12.18	Date: 11/12/19

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

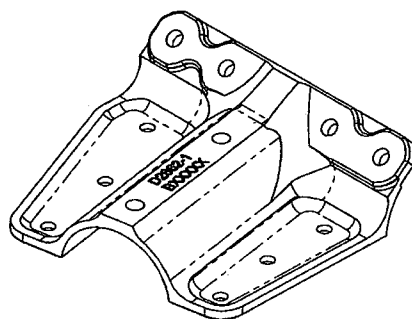
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

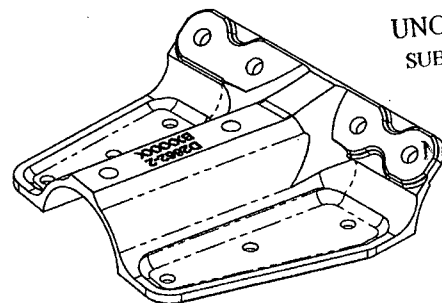
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT CHARGE
WORK ORDER
76807

11-11-21

RELEASED
2011-11-16
JNY

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2, B5-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	Q	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	Q		
CHECKED	A.S.	DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

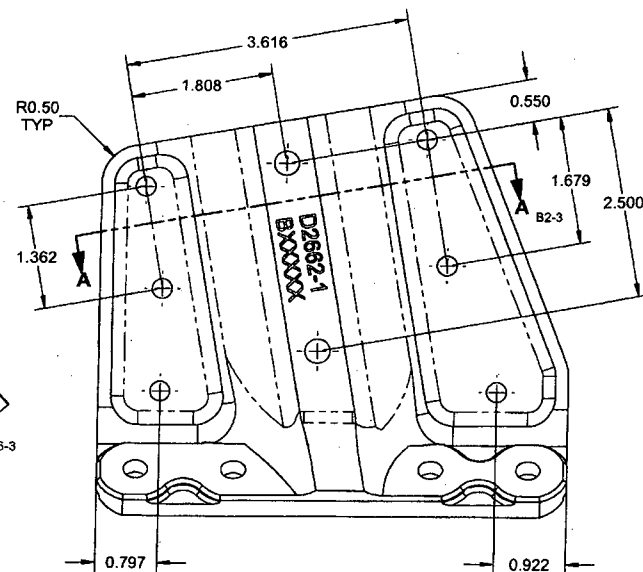
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1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010

7) WEIGHT: 0.66 lbs

76807

RELEASE
2011-11-16

DESIGN	<i>g</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE COPYRIGHT © 1957 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV. E
DRAWN	<i>AS</i>		SHEET 2 OF 5
CHECKED	<i>AS</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.10.31		

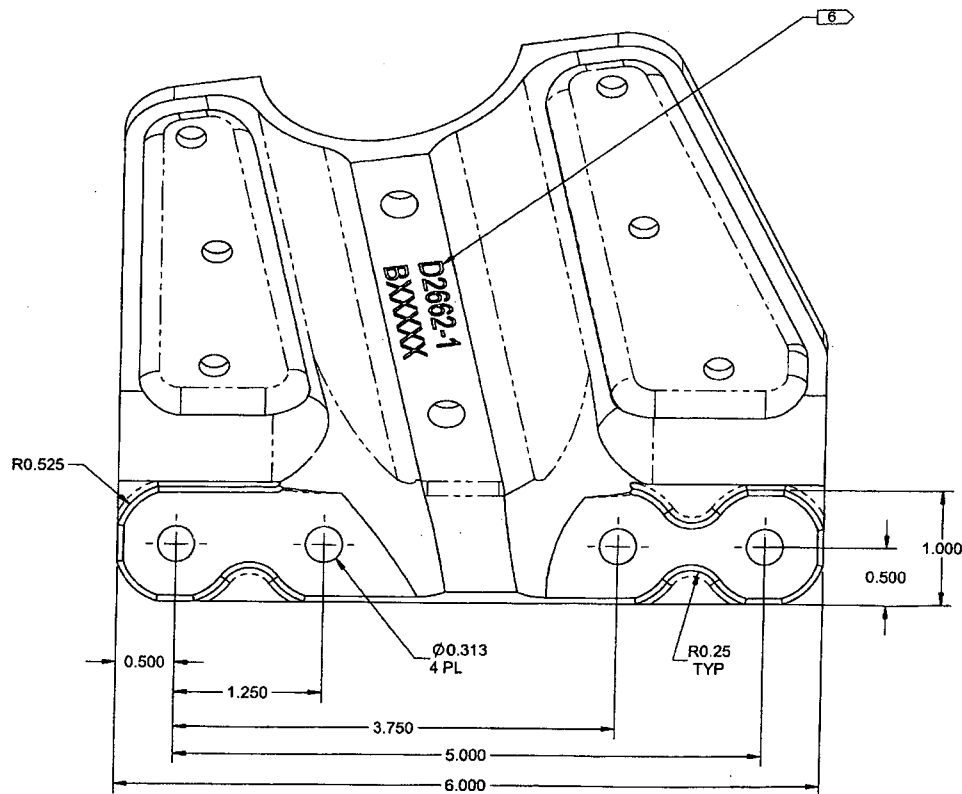
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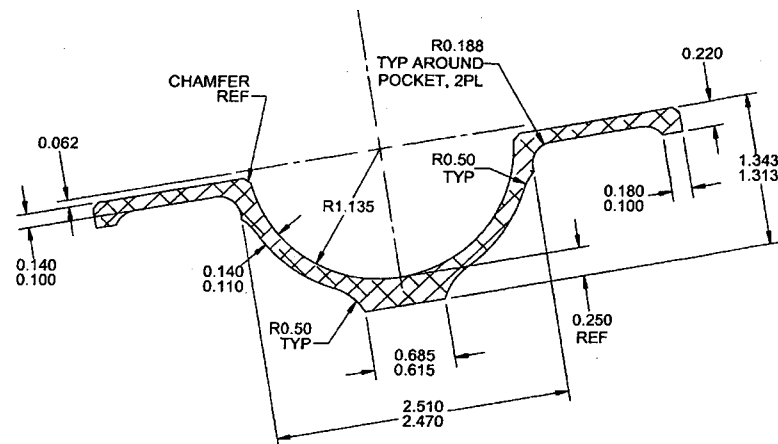
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VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16

76807

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	92	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	SM	D2662	SHEET 3 OF 5
APPROVED	SM	TITLE	SCALE
DE APPR.	#	SADDLE, INSIDE	NTS
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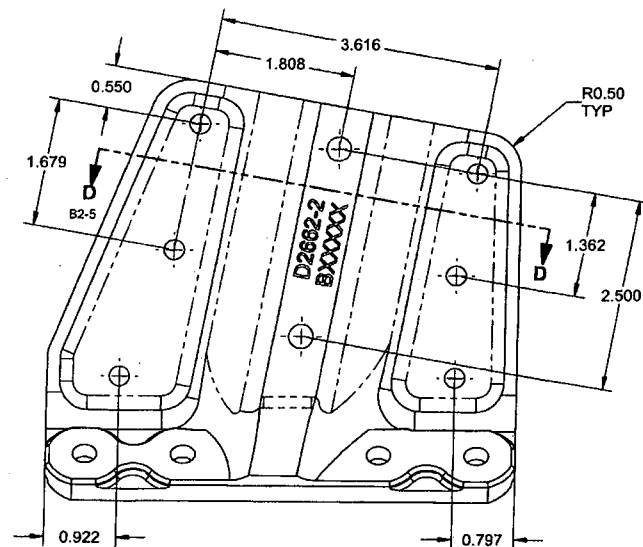
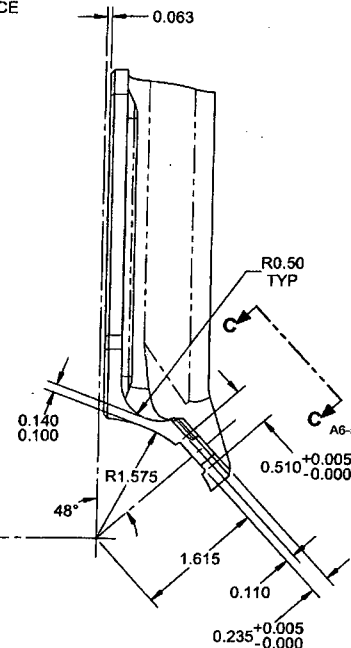
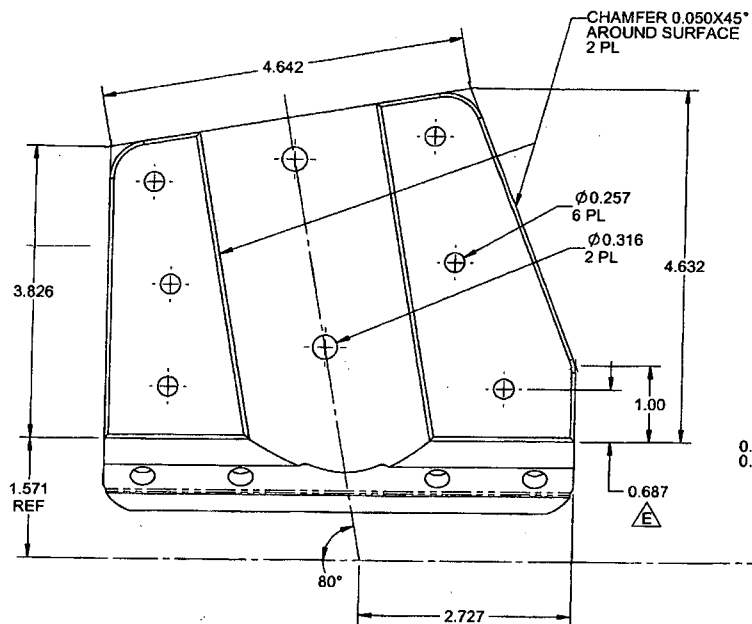
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D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
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2011-11-16

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